

Date: Monday, 3/26/2007 12:25:09 PM
 User: Eric Charbonneau

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET	
Job Number	: 31478		Part Number	: D35701	
Estimate Number	: 12679		Drawing Number	: D3570 UNDER REVIEW	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 3/26/2007 S.O. No. : N/A		Drawing Revision	: U/R	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 4/2/2007 Qty: 2 Um: Each	
Previous Run	: 30494				
Written By	: <u> </u>				
Checked & Approved By	: _____				
Comment	: Est Rev:A New Issue 07-01-30 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S125	6061-T6 .125 Sheet Comment: Qty.: 0.0746 sf(s)/Unit Total : 0.1491 sf(s) 6061-T6 .125 Sheet Batch: <u>M 103156</u> <u>ml 07 03 27</u> (2)
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3570 Dwg Rev: <u>U/R</u> <u>ml 07 03 27</u> (2) Prog Rev: <u>U/R</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>ml 07 03 27</u> (2)
4.0	QC8	SECOND CHECK Comment: SECOND CHECK <u>E 07 07 27</u>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per Dwg D3570 <u>N/A</u>

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BRACKET
Job Number: 31478		Part Number: D35701
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5 	INSPECT WORK TO CURRENT STEP ENGINEERING APPROVAL 
Comment: INSPECT WORK TO CURRENT STEP		4/6 07.03.27 R 07.03.27
7.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
8.0	POWDER COATING 	POWDER COATING 
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3		ENGINEERING APPROVAL JIA
9.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		5 FOR ENGINEERING USE ONLY
10.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock Location: _____		FOR ENGINEERING USE ONLY R 07.03.27
11.0	QC21 	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		10/07/03/29
Job Completion 		W 07.03.29
6.1 Drill Holes IAW Dwg D35701 and trim  070329		

DART AEROSPACE LTD	Work Order:	31478
Description: Bracket	Part Number:	D3570-1
Inspection Dwg: D3570 Rev: U/R		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 2.25	+/-0.030	2.253	✓		vern	
B 4.63	+/-0.030	4.63	✓		vern	
C R0.13	+/-0.030	R0.13	✓		Radius Gauge	
D 2.50	+/-0.030	2.50	✓		vern	
E 3.00	+/-0.030	3.00	✓		vern	
F 0.63	+/-0.030	0.610	✓		Height Gauge	
G 1.63	+/-0.030	1.603	✓		Height Gauge	
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	M. M	Audited by:	B	Prototype Approval:	N/A 16
Date:	07.03.27	Date:	07.03.27	Date:	N/A 07.03.27

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	



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Alcoa Europe

Fiat Rolled Products
 Alcoa Trasformazioni srl
 Stabilimento di Fusina
 Via dell'Elettronica 31
 30030 Malcontenta
 Loc. Fusina (Venezia)
 Italia
 Tel: 39 041 2917111
 Fax: 39 041 2917170

49381

INSPECTION CERTIFICATE

EN 10204 3.1

Ordernumber Alcoa 600198001
 Date 24/03/2006

Shipment doc.rif. 003820

AMARI METALS BV
 P.O. BOX 1274
 3430 BG NIEUWEGEIN NL
 NETHERLANDS

Vs.ordine nr. 055779DRB23800 Your alloy 6061 Your temper T6 Quantity 13283 Libbre

Global specification

ALU SHEET 6061 T6 Dimensions B209/AMS QQA 0,1250 x 48,00 x 96,00 Pollici

Remarks

THE PRODUCT MEETS ALL REQUIREMENTS OF:

AMS 4027 AMS QQ-A-250/11 ASTM B209

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AMS 4027 AMS QQ-A-250/11 ASTM B209

Chemical composition

Cast. nr		%Si	%Fe	%Cu	%Mn	%Mg	%Cr	%Ni	%Zn	%Ti	Altre	Totale
86018C5	TNT3A	0,74	0,44	0,24	0,070	1,06	0,13	0,0044	0,017	0,015		
Limit	Min.	0,40		0,15		0,80	0,040					
	Max.	0,80	0,70	0,40	0,15	1,20	0,35		0,25	0,15	0,050	0,15

Mechanical properties

Coil nr:		Rm	Rp0.2	A50
	Pallet	KSI	KSI	%
TNT3A		48	41	16
TNT3A.		47	41	14
0531817				
0531818				
0531819				
0531820				
Min.		42	35	10
Max.				

Approved by
 R. Signori Test.Lab.Supervisor

We hereby certify, that the material described above has been tested and complies with the terms of the confirmation of order.